



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004549

D350-567-031
Job Sheet 180320



Part No: D350-567-031

Job Qty: 1 ea

Part Name: Interior Window For -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9745-011 REV A, IIN-D350-567 REV E SHEET 28 IPP Rev:A new issue 08-04-25 DD verified by: LL
IPP Rev:B 08-10-07 as per revD DD verified by: IPP REV:C 13.10.15 AS PER IIN REV.E DD VERF:JLM IPP
REV:D 16.04.25 as per chg002 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Stores/Pkg-2		JUL 20 2018
110	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 20 2018
120	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC4		SmB
130	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		SmB
135	DC	1 pcs	7/20/18	7/20/18	0.00	0.00	DC		DAS
140	QC21-FG	1 Ea	7/20/18	7/20/18	0.00	0.00	QC21	JUL 30 2018	53 9-89

Part Op 110 - cut as per drawing
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-4A	Bolt	4 Ea (4 ea)	90-Start up Operation	5060008
AN526C632R12	Screw	8 Ea (8 ea)	90-Start up Operation	5024841
D3210-1	Doubler For Interior Window -015 & -025	1 Ea (1 ea)	90-Start up Operation	5044865
D3211-1	Bracket For Interior Window For -015 & -025	1 Ea (1 ea)	90-Start up Operation	3081643
D3212-1	Replacement Interior Window For -015 & -025	1 Ea (1 ea)	90-Start up Operation	7164117
D3213-041	Replacement Interior Door For -015 & -025	1 Ea (1 ea)	90-Start up Operation	7163860
D5420-1	Doubler Plate	1 Ea (1 ea)	90-Start up Operation	5049955
MS20426AD3-5	Rivet	8 Ea (8 ea)	90-Start up Operation	5006869
MS20470AD4-5	Rivet, Universal Head	40 Ea (40 ea)	90-Start up Operation	5049829
MS20470AD4-6	Rivet, Universal Head	90 Ea (90 ea)	90-Start up Operation	5048899
MS20470AD4-7	Rivet, Universal Head	20 Ea (20 ea)	90-Start up Operation	5048900
MS21042L06	Nut	8 Ea (8 ea)	90-Start up Operation	5049834
MS21062L3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	5065260
NAS1149DN632J	Washer	8 pcs (8 ea)	90-Start up Operation	5050482
D2463-0450	1/2" Seal-0.450"	1 Ea (1 ea)	90-Start up Operation	5077578

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-4A	4	271	0
	AN526C632R12	8	108	0
	D2463-0450	1	4	0

~~D5420-1~~ Not on blue file.

~~MS21062L3~~ Not on blue file.

Flex 7/4/18 1:36 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																			
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D3210-1	1	2	0
D3211-1	1	4	0
D3212-1	1	5	0
D3213-041	1	2	0
D5420-1	1	10	0
MS20426AD3-5	8	7,982	0
MS20470AD4-5	40	2,233	0
MS20470AD4-6	90	2,661	0
MS20470AD4-7	20	2,227	0
MS21042L06	8	102	0
MS21062L3	4	87	0
NAS1149DN632J	8	193	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 1:36 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

25.7 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 YD ²	2 YD ²	2 YD ²			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		9	8	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	8	8	AN960JD6	WASHER
		9	8	8	MS21042L06	NUT (OR MS21042-06)
		2	40	40	MS20470AD4-5	RIVET
		115	90	90	MS20470AD4-6	RIVET
		15	20	20	MS20470AD4-7	RIVET

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EDIT 5.0/25.7 PARTS LIST:

For customers with kits D350-567-013/-015/-017/-023/-025/-027/-117 @ CHG002 and earlier,
Customers with kits D350-567-111 @ CHG006 and earlier,
Customers with kits D350-567-115 @ CHG004 and earlier,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG001 and earlier,
Procure kit DSI 9745-011

REFERENCE ONLY

Item	Qty -011	Part Number	Description
	X	DSI 9745-011	FIRE EXTINGUISHER RELOCATION KIT
1	1	D5420-1	DOUBLER PLATE
2	4	AN3-4A	HEX HEAD BOLT
3	8	MS20426AD3-5	CSK RIVET
4	4	MS21062L3	NUTPLATE

For customers with kits D350-567-013/-015/-017/-023/-025/-117 @ CHG003 and later,
Customers with kits D350-567-111 @ CHG007 and later,
Customers with kits D350-567-115 @ CHG005 and later,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG002 and later,
Refer to Installation Instructions D350-567 and ICA-D350-567 and update the parts list as follows:

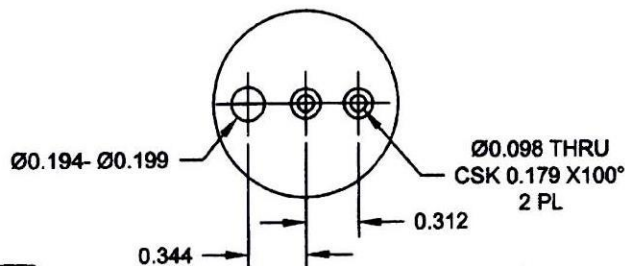
EDIT 5.0 ADD:

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
			1	1	D5420-1	DOUBLER PLATE
			4	4	AN3-4A	HEX HEAD BOLT
			8	8	MS20426AD3-5	CSK RIVET
			4	4	MS21062L3	NUTPLATE

EDIT 4.0/25.5 WEIGHT AND BALANCE:

*Note: Does not include fire extinguisher weight

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9745-011 (Primary Location)	0.1 lb	+1.6 in	+16 in lb	72.2 in	7.2 in lb
Fire Extinguisher Relocation Kit	0.05 kg	+0.04 m	+0.02 m kg	1.83 m	0.1 m kg
DSI 9745-011 (Alternate location)	0.1 lb	-4.4 in	-44 in lb	65.4 in	6.5 in lb
Fire Extinguisher Relocation Kit	0.05 kg	-0.11 m	-0.01 m kg	1.66 m	0.1 m kg

**DETAIL A**

(NUT PLATE HOLE PATTERN)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 16.04.06
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9745	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE FIRE EX LOCATION	NTS
DATE	16.04.06	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-567-031

Description: INTERIOR FLOOR WINDOW INSTALLATION, SLIDING DOOR COMPATIBLE

[illegible]